

Date: Wednesday, 09/04/2008 9:18:32 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 38506
Estimate Number : 13099
P.O. Number :
This Issue : 09/04/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : THERMOFORMING
Previous Run : 37666
Written By :
Checked & Approved By : JD 08.4.09
Comment : Est. Rev. A 07/12/13 DL verified by:DD

Drawing Name : PANEL-350 FWD CANOPY
Part Number : D36563
Drawing Number : D3656 REV A
Project Number : 00204
Drawing Revision : A
Material :
Due Date : 30/04/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s)
GE PLASTICS LEXAN SHEET
batch: M107574

ATC.
BB 08/09/10 x6

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 08/04/10 x6

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. A
Folio Rev. A

BB 08/04/10 x6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 08/04/10 (x6) x6 - PTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.04.10	1	Change material usage to 34.66 sq. ft to. remove leftover unusable material from stock. (correct estimate)	DL	08.04.10.		<i>[Signature]</i> 08-09-17	<i>[Signature]</i> 08-09-17

Part No: D3656-3 PAR #: N/A Fault Category: Pod/Thermforming NCR: (Yes) No DQA: D Date: 08/09/17
D350-766-013. QA: N/C Closed: D Date: 08/10/17

NCR: <u>38506</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.10	4.	Parts did not form. x4 webbing.	<i>[Signature]</i> 08/04/10	Scrap & destroy Qty 4 Modify tool to control webbing work in process	<i>[Signature]</i> 08.04.10	<i>[Signature]</i> 08-04-24	<i>[Signature]</i> 08/04/10	<i>[Signature]</i> 08/04/10
08.04.10	6.	R.C: too much material in one spot, on the fwd corners of the mold.						

NOTE: Date & initial all entries

Date: Wednesday, 09/04/2008 9:18:32 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 38506

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



08/04/11
DH
x2

Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08/04/11
DH
x2

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/04/11
DH
x2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



08/04/11 (x2)

Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/04/11 (x2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER: 38506
Description: PANEL 350 FWD CANOPY	Part Number: D36563
Inspection Dwg: D3656 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Tight, even radius throughout part	OK
Acceptable shape definition	OK
Acceptable texture retention	OK
Free of visual flaws (bumps, cracks, voids, etc.)	OK

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D36563 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.75	.1	40.75	✓		tap	
60.25	.1	60.25	✓		shape	
0.045	.002N.	0.058	✓		vern	
0.050	min	0.053-0.060	✓		Mic	

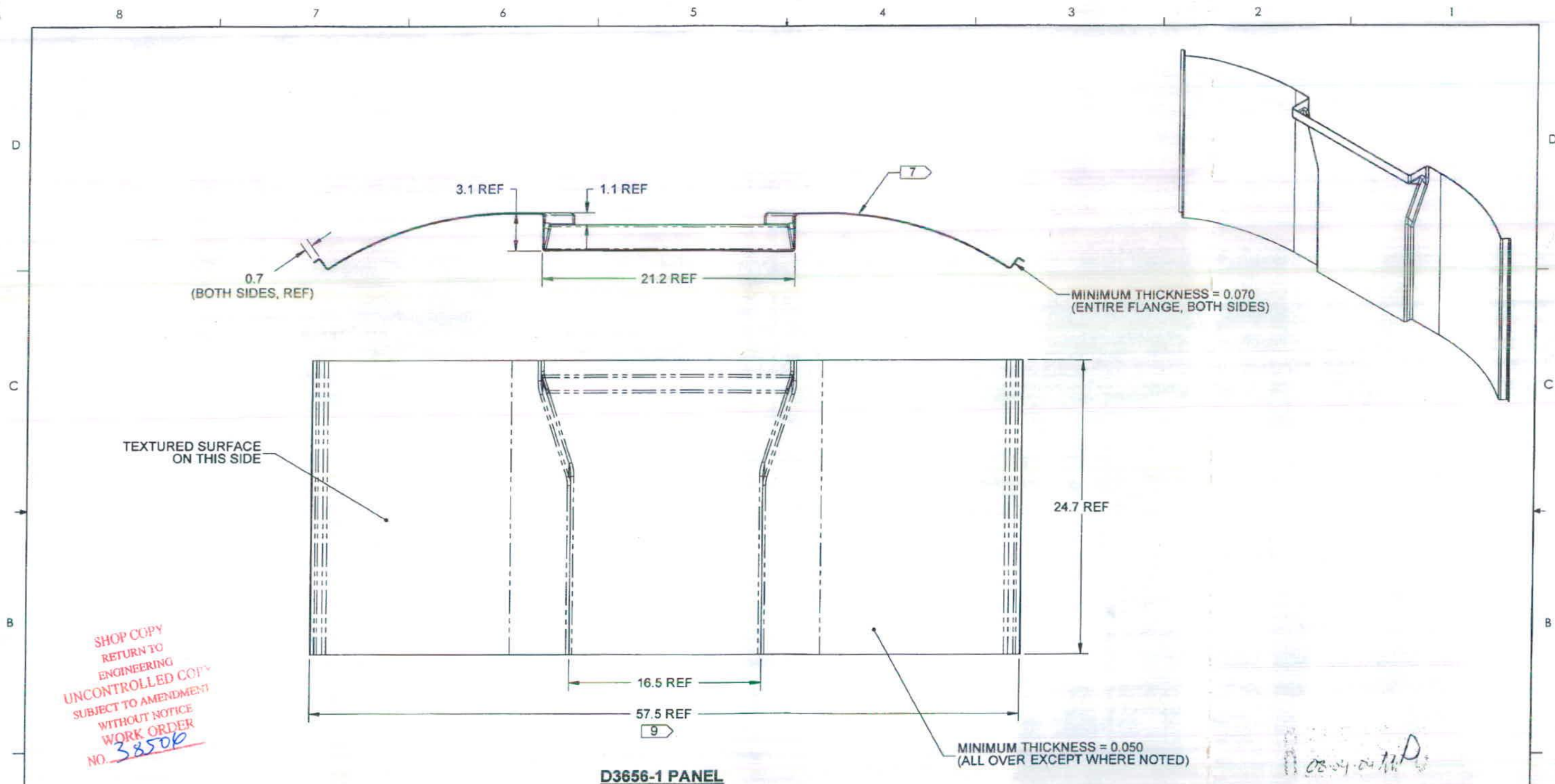
Measured by: OK
Date: 08-04-10

Audited by: [Signature]
Date: 08-04-10

Prototype Approval: [Signature]
Date: 08-04-10

Rev	Date	Change	Revised by	Approved
		New Issue		

[Signature]



NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A	SHEET 1 OF 2
DRAWN	LE			
CHECKED	RA			
MFG. APPR.	RA			
APPROVED	MD			
DE APPR.	MD	PANEL	SCALE	NTS
DATE	08.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

D

C

B

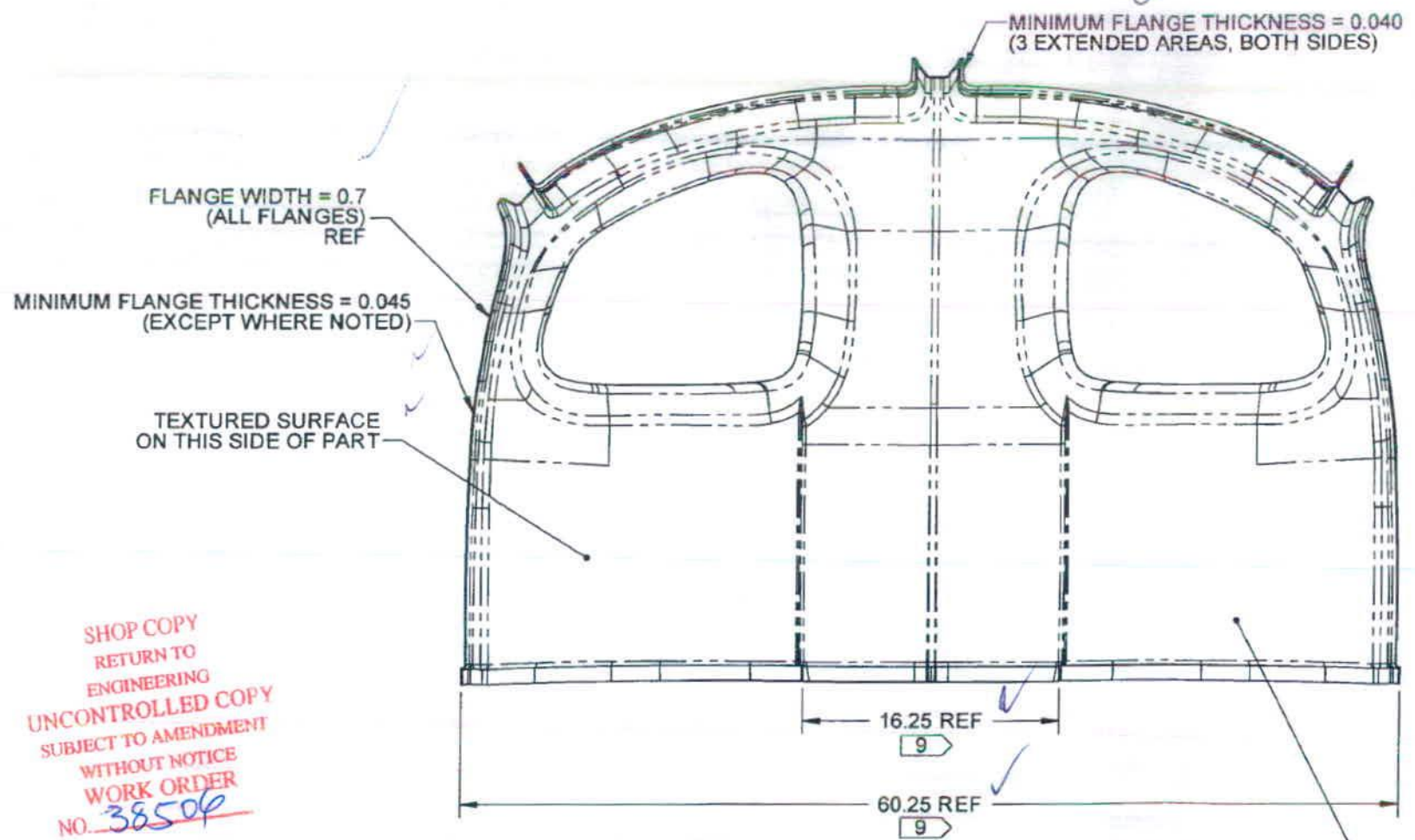
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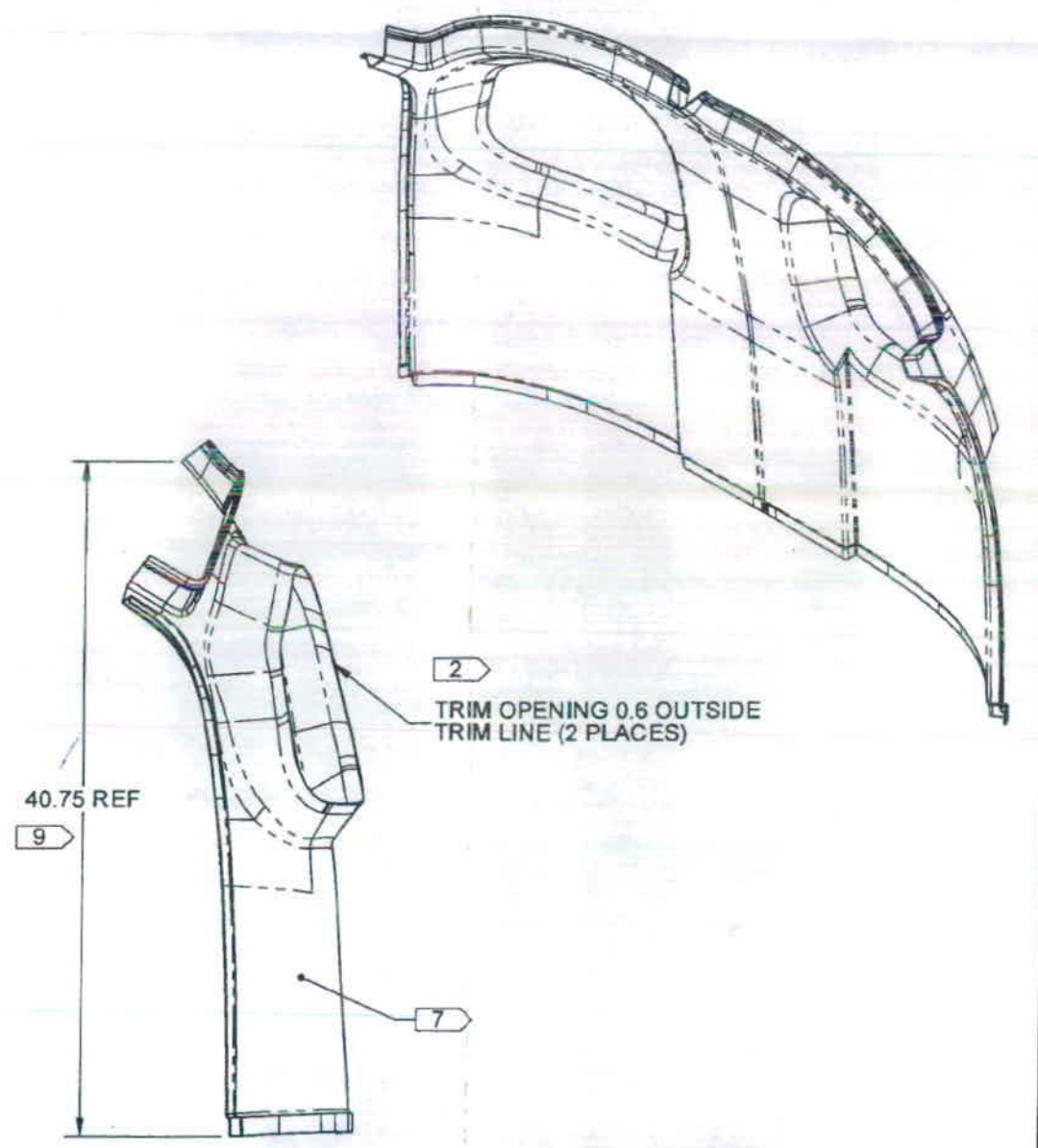
C

B

A



D3656-3 PANEL



MINIMUM THICKNESS = 0.050
(ALL OVER EXCEPT FLANGES)

- NOTES:
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
 - 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
 - 8) WEIGHT: 8.7 lbs
 - 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. A
MFG. APPR.	WHP	D3656	SHEET 2 OF 2
APPROVED	WHP	TITLE	SCALE
DE APPR.	WHP	PANEL	NTS
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